

PIPE RENOVATING SYSTEM AND METHOD

CROSS REFERENCE TO RELATED APPLICATIONS

[0001] This application is a Continuation-In-Part of pending Application Serial No. 10/316,255 filed December 9, 2002.

BACKGROUND OF THE INVENTION

[0002] The present invention relates to a system and method for renovating pipes by removing accretions or build up in the pipes and then coating the pipes with a coating material.

[0003] All types of pipes, such as water pipes, gas pipes, sewer pipes, industrial fuel, chemical manufacturing plant pipes, and the like, are susceptible to build up of accretions or scale on the inner surface of the pipe. One of the reasons for this is corrosion or rust of the pipe surface. Another reason for scale build-up is the deposit of accretions from the material flowing through the pipe onto the pipe surface, such as lime or other deposits of solids from water in a water pipe. These accretions lead to a narrowing of the pipe diameter, reducing the throughput, and the formation of pits, ultimately jeopardizing the pipe integrity and leading to premature failure of the pipe system.

[0004] Renovating existing pipes will reduce the need for a complete or partial replacement of a piping system. This is of great advantage where pipes are installed below the ground, inside walls, or in shafts. The only thing that needs to be done is to dismount the instruments and devices at each end of the pipe and to mount them again after the pipe is cleaned and coated. Various pipe renovating systems and methods have

been proposed in the past. In some cases, compressed air carrying particles of abrasive material is blown through the pipe. Such a method is described, for example, in U.S. Patent No. 5,924,913 of Naf. The interior of the pipe is subsequently coated with an adhesive resin, such as an epoxy resin, which is also applied by use of compressed air to blow it through the pipe.

[0005] Processes using compressed air in this way can only be used on relatively small diameter pipes, and this cleaning technique can easily result in blocking of the pipe, or major leaks in the pipe when weakened after cleaning by constant high pressure. Pipes may not be adequately cleaned by such a method when major frictional resistance occurs in the pipe system.

[0006] U.S. Patent No. 5,924,913 of Reimelt attempts to overcome these problems. In this method, cleaning abrasives are moved back and forth in the pipe by means of an alternating pressure drop. This may be done by alternately applying a vacuum to opposite ends of the pipe, or alternately supplying compressed air to opposite ends of the pipe. However, this technique can also result in blockages. When an abrasive agent is repeatedly moved back and forth, it will gradually become mixed with the accretions removed from the pipe surface, diluting or reducing the cleaning effect.

SUMMARY OF THE INVENTION

[0007] It is an object of the present invention to provide a new and improved method and apparatus for renovating pipes.

[0008] According to one aspect of the present invention, a pipe renovating method is provided, which comprises the steps of:

supplying a flow of pressurized gas and abrasive material to a selected pipe inlet;

connecting a discharge end of the pipe to a vacuum, whereby the gas and abrasive material is pumped in at the inlet end and sucked out at the discharge end; and

the vacuum flow rate at the discharge end being higher than the gas input flow rate at the pipe inlet whereby the pressurized gas and abrasive material will be steered from the selected pipe inlet to the discharge end of the pipe.

[0009] With this arrangement, the pressurized gas and abrasive material can be successively connected to a series of different inlets to a pipe system, with the vacuum connected to an outlet or discharge end, and the higher suction will tend to steer the gas and abrasive material along the desired section of pipe to be cleaned. In an exemplary embodiment of the invention, the ratio of the vacuum or suction flow rate at the discharge end to the inlet flow rate is of the order of 20:80 push to pull, or 80% vacuum or suction flow rate to 20% inlet flow rate. However, the ratio may be in the range from 10:90 to 40:60.

[0010] In an exemplary embodiment, the inlet end of the pipe is connected to a compressor and a supply of abrasive material, while the outlet end is connected to a vacuum pump. This has the advantage that increased gas flow is achieved by the combination of pressure at one end of the pipe and vacuum at the other, reducing the risk of blockages and eliminating or reducing the problem of loss of pressure at bends or elbows in the pipe, since the gas is being pulled through such obstructions by the

vacuum even though pressure will be lost. The combination of blowing in air or other gas at one end of the pipe and sucking out the gas or air at a higher rate at the other end of the pipe may be known as vacuum acceleration and steering. Even though the pressure at both the intake side and the discharge side may be well below the maximum pressure permitted for safety purposes, the particles and gas can still be transported at high speed throughout the entire pipe or pipe system. The higher flow rate at the discharge end will help to steer the gas and abrasive particle mixture in the correct direction, avoiding or reducing loss of pressure as a result of gas tending flow in both directions at a T-junction, for example, which may occur if the inlet flow rate is the same as the outlet flow rate at the vacuum end.

[0011] The pipe may be dried prior to the abrasive treatment, by blowing heated air through the pipe. A coating material may be applied to the surface of the pipe after cleaning in a similar manner, simply by replacing the supply of abrasive material with a supply of coating material. The coating material is then conveyed through the pipe by blowing it in at one end and sucking it out at the other end, with the same ratio of inlet:discharge flow rates. The pipe may be heated again after the cleaning is complete and prior to applying coating material, in order to improve the flow characteristics of the liquid coating. The combination of pressure at the intake end with vacuum applied at the discharge end (push and pull) applies a high air or gas volume and speed, transporting the coating material, such as epoxy, through the pipe quickly and evenly. This eliminates or reduces variations in epoxy distribution which can arise when only pressure or only vacuum is used, such as uneven thickness or missed areas.

[0012] According to another aspect of the present invention, a system for renovating of pipes is provided, which comprises a supply of pressurized gas for connection to a first end of a pipe, a supply of abrasive particulate material for supplying to the first end of the pipe together with the pressurized gas, and a vacuum pump for connection to a second end of the pipe, whereby the abrasive material is blown into the pipe at one end and sucked out of the pipe at the other end, with the vacuum flow rate at the second end being greater than the inlet flow rate.

[0013] An air heater may also be connected between the gas supply and first end of the pipe, and a coating material supply may be provided to replace the abrasive material supply when the pipe has been sufficiently cleaned, so as to coat the interior of the cleaned pipe with a layer of coating material such as epoxy. A filter is provided at the second end of the pipe for filtering the separated accretions from the pipe from the abrasive material.

[0014] The pipe renovating system and method of this invention allows pipe systems to be cleaned and coated more effectively than in the past, and also allows pipes of much larger diameter to be cleaned and coated. The combination of push at one end and pull at the other end of the pipe will reduce the effect of fall off of pressure half way along the pipe or at bends or elbows, and will move a larger volume of air at a higher speed through the pipe than would be possible by application of pressure or vacuum alone. The differential flow rate between the selected inlet and the discharge end will steer the gas and abrasive particle or coating material in the correct direction, and allow a lower overall pressure to be used in the system, which is safer. This system and method will

clean and coat pipes more reliably and uniformly, and reduce the risk of blockages or pipe blow outs.

BRIEF DESCRIPTION OF THE DRAWINGS

[0015] The present invention will be better understood from the following detailed description of an exemplary embodiment of the invention, taken in conjunction with the accompanying drawings in which like reference numerals refer to like parts and in which:

[0016] Figure 1 is a block diagram illustrating the pipe cleaning stage of the method according to an exemplary embodiment of the invention;

[0017] Figure 2 is a block diagram illustrating the subsequent, pipe coating stage;

[0018] Figure 3 is a cross-section through part of a pipe wall at a junction illustrating the application of a first layer of a coating material;

[0019] Figure 4 is a cross-section similar to Figure 3 illustrating application of a second layer of coating material;

[0020] Figure 5 is a block diagram of a pipe system being cleaned according to a prior art method using only a supply of compressed air; and

[0021] Figure 6 is a schematic block diagram illustrating the steering technique of this invention.

DETAILED DESCRIPTION OF THE DRAWINGS

[0022] Figures 1 to 4 and 6 of the drawings illustrate a system and method for renovating pipes according to an exemplary embodiment of the invention. The method may be used for renovating pipes in any type of pipe system, including water pipes, gas pipes, sewer pipes, oil pipes, pipes in chemical plants, pipe systems on ships and other vessels, air conditioning pipes, storm drain systems, fire sprinkler systems, and the like. This will prolong the lifetime of a pipe system and reduce or avoid the expense of replacing all or part of a pipe system.

[0023] Figures 1 and 2 illustrate a simplified view of part 10 of a pipe system to be renovated. It will be understood that a typical pipe system will include joints, bends, elbows, connections, and the like, which are not illustrated in the drawing. Figure 1 illustrates the pipe cleaning stage of the method, while Figure 2 illustrates the pipe coating stage. The system as illustrated in Figure 1 basically comprises a compressor 12 for providing a supply of air under pressure to a first intake or selected part 14 of the pipe system 10, and a vacuum pump 15 connected to a selected second port 16 of pipe system 10. It will be understood that the pipe system in Figure 1 is a simplified system for illustration purposes only, and that a typical pipe system will be much more complex, with more pipe fittings, elbows and junctions. The same basic system may be adapted for any pipe arrangement. An air heater 18 is connected to the outlet of the compressor 12, and a particle mixer or revive machine 20 is connected via a valve 22 to a first outlet 24 of the machine 18. Machine 20 has an inlet 25 for receiving sand-blasting material or abrasive granulate material, such as a chemically inert non-metallic mineral, emery, quartz, sand, glass, metal particles, or the like.

The outlet of machine 20 is connected via valve 26 to the intake 14, in the condition illustrated in Figure 1.

[0024] The air heater 18 also has outlets 28,29,30 connected via lines 32,34,35, respectively, directly to three different intakes 14, 36,38 of the pipe system part 10, with valves 40,42, 44 controlling the connection of the respective heater outlet to the pipe system intake, as discussed in more detail below. Valves 45,46 in lines 34,35 allow the pressurized air and granulate material from machine 20 to be selectively supplied to the other two intakes 36,38 of this part of the pipe system. It will be understood that a greater or lesser number of lines and valves will be used if the pipe system has more or less ports or intakes to which fixtures or armatures are connected. Alternatively, in a simpler arrangement, a single connecting hose connected to the particle mixer outlet may be successively connected to a series of different intakes or ports in a pipe system.

[0025] A separate pressure control manometer (PCM) 48 is connected to each of the connecting lines or hoses 32,34,35, and each PCM is connected to a control input of compressor 12 via control line 49, such that the compressor is automatically shut down if the pressure detected exceeds a predetermined safety level. A separate thermometer with thermostat (T/T) 50 is also connected to each of the hoses 32,34,35 to detect the temperature at that point in the hose, just prior to the respective intake 14, 36, 38. Each thermostat 50 is connected by a control cable 52 to a heater control unit 54, which in turn controls the operation of the air heater 18. A thermometer 55 is also connected to the hose 56 at the outlet end. Vacuum pump 15 has an inlet filter 58 for

filtering particles above a certain size from the mixture flowing out of outlet 16.

[0026] In order to clean a pipe system, the armatures and/or fixtures connected to part of the pipe system are first disassembled, and the pipe cleaning system is then connected to opposite ends of part of the pipe system as indicated in Figure 1. Initially, the pipe system and incrustations are dried by heating with heated air from the air heater 18. This is done by closing valves 22 and 26, and opening valves 40,42,44 so that heated air is blown through each of the pipe intakes 14,26,38 and through the pipe system 10 to the outlet end 16. Heated air will be blown in through each pipe intake, and will be pulled out by the vacuum pump 15. If the pipe is not dried before blowing through the dry granulate material, there is a risk that the dry granulate will become moist and tend to clump together, potentially blocking the pipe. Additionally, the drying of any encrustations or deposits on the inner wall of the pipe will make such encrustations looser and easier to remove. The pipe system is dried with dehumidified, pre-clarified air, at a temperature of between 50° C and 120° C above the surrounding ambient temperature.

[0027] After the drying step is completed, valve 40 is closed, and valves 22 and 26 are opened, so that pressurized air carrying the abrasive, sand blasting material particles is blown into the intake 14. At the same time, heated air may also be blown in to intakes 36 and 38 via lines 34,35, to prevent any back flow of the abrasive particles. The vacuum pump 15 operates simultaneously to pull the air and particles through the pipe part 10. By blowing in air at the intake side and simultaneously applying a vacuum at the outlet or suction side to suck air out at the outlet side, the pressure at each end of the pipe does not have

to be as high as would be necessary if vacuum alone or a pressure drop at one end only of the pipe were applied, for example as illustrated schematically in Figure 5. In this prior art arrangement, a very high pressure will be needed to blow the compressed air and abrasive, or compressed air and coating material, through a selected pipe section.

[0028] The “push and pull” method, as illustrated in Figures 1,2 and schematically in Figure 6, is a vacuum acceleration technique, and reduces the drop off in pressure which would otherwise be encountered at pipe fittings, bends, elbows, or partial blockages of the pipe. The air volume is blown in at one end at a high velocity and flow rate, and sucked out at the other end at a higher flow rate, which tends to steer the abrasive particle mixture in the desired direction. In this way, the pressure at both the intake side and the outlet side can be far below the maximum safety level, such as 15 PSI, while still acting to transport the air and abrasive particles at very high speed. The pressure control monitors will operate to automatically open a pressure relief valve if the pressure exceeds 15 PSI (or any other preset safety level, depending on the pipe system).

[0029] The abrasive particles blown through the pipe will hit the inner wall of the pipe at high velocity, tending to loosen and strip off any accretions or incrustations which have built up on the pipe surface. Not only are the accretions removed, but the high velocity, high volume of air will tend to heat up the pipe. The abrasive material used may be any kind of airborne particles which are harder than the inside accretions to be removed. In the case of water pipes, the particles must be of a mineral that poses no health risks and is approved for use in water pipes. In this case, the particles will have a grain diameter in the range from #5 mesh to #250 mesh (U.S. standard sieves). Suitable particles include chemically

inert, non-metallic minerals, emery, quartz sand, or metal particles, particularly ferromagnetic particles. In an exemplary embodiment of the invention, the abrasive material used was Emerald Creek Garnet, produced by Emerald Creek Garnet Co. of Idaho, U.S.A.

[0030] It has been found that the combination of pressure and vacuum at opposite ends of a pipe section provide the air flow and volume needed to adequately clean the inside of the pipe and to reduce the risk of blockages. It has also been found that, by providing a higher vacuum or "pull" at the vacuum end of the pipe, relative to the input or "push" at the compressor end, steering of the gas mixture can be provided, as generally indicated in Figure 6. This is important when a large number of different sections of a pipe system must be cleaned. One example of this is a building fire sprinkler system. Build up of deposits within pipes of a fire sprinkler system can render it inoperative, requiring replacement of the entire system. With this invention, a vacuum pump 15 can be connected to the main inlet pipe of the sprinkler system, which acts as the "discharge end" of the pipe cleaning and coating system during the cleaning and coating process. All the sprinkler outlets are opened, and the compressor 12 (and abrasive material) is connected in turn to each sprinkler outlet (or cleaning system inlet 80,82,84), starting at the location closet to vacuum pump 15.

[0031] In Figure 6, the ratio of the supply of gas from compressor 80 to the vacuum at the discharge end is 20% to 80%. This will steer the gas mixture to the left at T-junction 85, so that it is pulled towards the discharge outlet of the pipe cleaning system, and no air pressure is lost at the junction with inlet 80. The higher vacuum pull will tend to steer the gas mixture in the direction of the vacuum, as indicated by the arrows in

Figure 6. This avoids the need to cap off the other ports 80,84 or to supply air to these ports to prevent back flow. Although the ratio of supply flow rate to vacuum flow rate in the exemplary embodiment is 20% to 80%, this ratio may be varied while still producing the desired steering effect. In practice, ratios from 5%:95% up to 40%:60% may be used effectively, with the optimum range being from 10%:90% up to 30%:70%.

[0032] Once the pipe section indicated in Figure 6 has been cleaned, the compressor is simply connected by a hose to the next sprinkler outlet 84 or other pipe system port, and the procedure is repeated to clean the part of the pipe between outlet 84 and the cleaning system discharge outlet. The compressor can be simply moved from sprinkler to sprinkler and room to room throughout the building, cleaning each part of the pipe system in turn. All that is needed is one hose to connect the compressor and particle mixer to the selected sprinkler outlet, and one hose to connect the main inlet pipe of the sprinkler system to the vacuum pump. Up until now, it has not been possible or economically practical to clean fire sprinkler systems, and replacement of such systems when blocked or deteriorated is both expensive and time consuming. The system of this invention provides an inexpensive method to clean such pipes, avoiding the need for relatively frequent replacement.

[0033] The same principle can be used to clean a sewer pipe system, moving from pipe inlet to pipe inlet in turn to clean successive lengths of sewer pipe. Other types of pipe system can be cleaned in a similar manner, using the differential ratio of vacuum to supply in order to steer the gas and abrasive particle mixture through the desired section of pipe.

[0034] The filter built in to the vacuum pump at the outlet end will remove the grit or sand blasting materials from the air, so that the material may be re-used. The abrasive particles will tend to spiral around the pipe as the air is blown through the pipe, such that they are blown onto the wall and will tend to strip of accretions or deposits which have built up inside the pipe.

[0035] The following table indicates a suitable air volume/flow rate for adequate cleaning of pipes of different diameters, in the range of 0.5 to 8 inches, although larger diameter pipes can also be effectively cleaned by means of an increase in air volume and flow. Thus, for a 2 inch diameter pipe, around 270 cubic feet of air per minute will be the desired air flow rate for pipe cleaning purposes.

TABLE 1
Air Volume per Minute for Different Diameter Pipes

<u>Pipe Size</u> <u>(inches)</u>	<u>CFM</u>	<u>Decimal of</u> <u>Inches</u>	<u>Gals. In Lineal</u> <u>Foot</u>
0.5	15.8125	0.5	0.0158
0.75	42.95	0.75	0.0277
1	69.6	1	0.0449
1.25	120.45	1.25	0.0777
1.5	163.95	1.5	0.1058
2	270.23	2	0.1743
2.5	385.57	2.5	0.2487
3	595.34	3	0.384
3.5	796.21	3.5	0.5136
4	1025.2	4	0.6613

4.5	1315.2	4.5	0.8284
5	1611.12	5	1.0393
6	2326.6	6	1.5008
8	4031.82	8	2.5988

[0036] In order to achieve a desired air flow rate of around 15 CFM for a relatively small diameter pipe, while maintaining the desired ratio of input flow rate to vacuum flow rate, the compressor air flow rate should be set at around 3 CFM while the vacuum flow rate should be around 12 CFM. Similar ratios can be determined readily for different desired flow rates, depending on pipe diameters. Although the range in pipe diameters in the table above is from 0.5 to 8 inches, the system can in practice be used to clean pipes up to 20 inches in diameter. The push and pull system makes it possible to clean even very large diameter pipes effectively, where the only option before was a very expensive replacement of pipe sections or the entire pipe system. A ratio of 20% push to 80% pull will be effective for all pipe diameters.

[0037] The dust and removed incrustations resulting from the cleaning are segregated in the vacuum filter collection unit. Once the mixture of air and abrasive particles has been blown through the pipe for a sufficient time, the compressor and vacuum pump are turned off, and an endoscope or profile plate test may be used to ensure that the pipe has been sufficiently cleaned. The pipe must be scaled to a coarse granulate roughness height in the range from 40-50 μm or 2-3 mils, in order to guarantee a good mechanical adhesion of the plastic in the pipe. Surface roughness is measured both at the intake and the outlet end of the pipe. If the test shows that the incrustations are still at a greater height than is recommended, abrasive particles and air are again blown through the pipe

from one end and pulled from the other end by the vacuum pump until the desired surface smoothness is reached.

[0038] Once the pipe section from inlet 14 to outlet 16 has been cleaned, the outlet of the particle mixer or sand blasting machine 20 is disconnected from valve 26 and connected to inlet valve or tap 45 of the hose 34. The procedure is repeated in order to clean the portion of the pipe extending from intake 36. Once this portion of the pipe is sufficiently clean, the outlet of the sand blasting machine 20 is disconnected from inlet valve 45 and connected to the inlet valve 46 of hose 35, and air and abrasive particles are blown into intake 38 and sucked out of the pipe system at outlet 16. This procedure is repeated for all pipe sections on a given floor or at a given level in a building, for example. The steering provided in this method avoids loss in air volume due to back flow at junctions in the pipe system, since it will always steer the air mixture towards the vacuum end of the pipe.

[0039] Any compressor and vacuum pump combination of sufficient capacity may be used for the pipe renovation system of Figures 1 and 2. Any suitable air compressor or equivalent device for supplying pressurized air may be used. For pipes of up to two inches in diameter, one suitable vacuum pump is the Jumbo Air Vacuum Pump (single, dual, or quad air) manufactured by Tornado Industries of Chicago, Illinois, which has an external filter. For pipes of larger than two inch diameter, a Vac-Tron vacuum pump manufactured by Vac-Tron Equipment of Okahumpka, Florida, or equivalent, may be used. For pipes of larger than four inch diameter, a Vactor vacuum pump, manufactured by Vactor of Streator, Illinois, may be used. A suitable air heater for use in the system is a flange circulation heater available from Gaumer Process Heaters, Systems,

Controls of Houston, Texas. However, other types of heaters may alternatively be used.

[0040] A suitable coating material is then applied to the pipe, using the system as illustrated in Figure 2, with the same push and pull ratios as described above in connection with the cleaning part of the process. The system as connected in Figure 2 is identical to that of Figure 1, except that the sand blasting or revive machine 20 is replaced by lining mixer 60, with an inlet 62 for receiving the selected lining material. The coating material may be a synthetic resin or plastic. It is selected based on the type of pipe, the pipe diameter, the pipe length, and the cure time. In an exemplary embodiment of the invention, the selected lining material was a two part epoxy material, such as APL - 2000[1] Protective (Barrier) Material as produced by American Pipe Lining, Inc. of San Diego, California, which is approved for use in water pipes. Alternatively, any suitable coating material which has an NSF 61 approval for water pipes may be used, such as Raven A-61 or Raven AquataPoxy A-61 manufactured by Raven Lining Systems of Tulsa, Oklahoma, or Pipe Tubeprotect coating material manufactured by A. Lehmann & Co. AG of Allschwil, Switzerland. Other coating materials may be used for different applications. For sewer pipes, Raven Aquatapoxy A-6 or AquataPoxy A-6 Thick may be used. For steam pipes up to 250° C, Simtecplast epoxy manufactured by A. Lehmann & Co. AG of Allschwil, Switzerland may be used.

[0041] One suitable mixer or machine for adding liquid epoxy to the air flow is the 10B Micro Piston Machine for pumping low to high viscosity liquids, manufactured by Integrated Dispensing Solutions of Woodland Hills, California. However, other mixers and dispensers for liquids such as epoxies may alternatively be used.

[0042] Prior to application of the epoxy coating to the pipe, a pressure test may be performed to determine whether there are any holes in the pipe, since otherwise the epoxy material could leak out of these holes, resulting in insufficient coverage. However, it has been found that the coating material will escape only in very small quantities if the holes are small, and will actually contribute towards sealing such holes, avoiding the need for using additional materials to seal any relatively small holes. In order to locate any larger holes which could be more of a problem, a pressure test may first be carried out following the pipe cleaning, using electronic or mechanical measuring devices as known in the pipe testing field. Alternatively, ultrasound may be used to locate leaks from the sound of escaping air. If only minor leaks are found, no repair is needed since the coating material itself will seal such leaks. If major leaks are discovered, a repair is performed prior to starting the pipe coating procedure.

[0043] Once it has been determined that there are no major leaks or all such leaks have been sealed, the pipe system is heated to a predetermined temperature prior to supplying epoxy material to coat the pipe. This temperature will give the epoxy better flow. The pipe system is heated with dehumidified, pre-clarified air supplied to the first intake 14 directly from air heater 18, while detecting the temperature at the intake with thermometer 50, and at the outlet with thermometer 55. The temperature of the pipe should be between 100° - 120° F during coating. Coating can commence when the temperature is not greater than 120° F at the inlet and not less than 80° F at the outlet end of the pipe.

[0044] When the pipe is at the right temperature, the epoxy components A and B can be mixed according to the specified ratio. The mixed epoxy is then introduced into the hose which is connected to the

prepared pipe at a selected inlet. Unlike the pipe cleaning process, the coating process starts at the port 38 (or port 84 in Figure 6) farthest away from the vacuum pump. At the other end of the pipe, the vacuum pump sucks or pulls the epoxy through the pipes. As in the cleaning step, pipe coating is carried out using the combination of the compressor 12 at the intake end and the vacuum pump 15 at the outlet end, both pushing and pulling the air and epoxy material through the pipe, with the push to pull ratio being of the order of 20% to 80%. This push and pull system supplies a high air volume and speed which transports the epoxy through the pipe quickly and evenly, reducing the risk of blockages, and steers the epoxy through the selected pipe section, reducing or eliminating the risk of excess epoxy traveling in the wrong direction. The high air volume, which will be equivalent to that illustrated in Table 1 above, causes an eddying core flow in the pipe that throws or presses the coating material against the inner wall of the pipe, while the air flow velocity will provide an even coating layer along the pipe. The method will reduce or eliminate mistakes as a result of poor epoxy distribution which may be caused by using only pressure or only vacuum to transport the epoxy, such as uneven thickness or missed areas.

[0045] A transparent pipe or tube attached at the outlet end 16 of the pipe shows when the epoxy has traveled all the way through the pipe. The air flow is then slowed to a minimum so that epoxy no longer travels through the pipe system. This helps the epoxy to dry and cure more quickly. Table 2 below allows the amount of coating material necessary to coat the pipe to be determined, ensuring that only small amounts escape from the other end of the pipe, protecting the environment and saving costs.

[0046] The amount of epoxy to be used is calculated using Table 2 below, based on the pipe material, length, and diameter.

Table 2
Pipe Lining Coating Distance Chart

Galvanized Iron Pipe:

<u>Pipe Size I.D. (inches)</u>	<u>1-Cup 1 lb. (feet)</u>	<u>1 Gal. 10 lbs. (feet)</u>	<u>5 Gals. 50 lbs. (feet)</u>
6	3	30	150
5	3.5	35	175
4	4.5	45	225
3	6	60	300
2.5	7	70	350
2	9	90	
1.5	12	120	
1.25	14	140	
1	18	180	
0.75	24	240	
0.5	36	360	

Copper Pipe:

<u>Pipe Size (O.D.) (inches)</u>	<u>1-Cup 1 lb. (feet)</u>	<u>1 Gal. 10 lbs. (feet)</u>
2	9.5	95
1.5	13	130
1.25	16	160
1	21	210
0.75	28	280
0.5	48	480

[0047] Once the calculated amount of epoxy has been supplied to the pipe and the epoxy material is seen at the clear pipe connected to pipe end 16, the lining mixer is turned off and the air flow is reduced. The procedure is repeated for all pipe sections, connecting the lining mixer in turn to the intake 36 and 14, and supplying sufficient epoxy to coat that section of the pipe. The thermostats will ensure that the pipes are maintained at a sufficiently high temperature during the entire procedure, by controlling the heater control unit to heat the air if the detected temperature falls below a predetermined level. Once all pipe sections are coated, the lining mixer is turned off, and the system is left for 24 hours to allow the epoxy to dry and cure. After 24 hours, the epoxy will be hardened enough to use the pipe.

[0048] In order to coat a pipe having plural junctions and ports, as in Figure 1, the total length of pipe to be coated is first measured. The amount of coating material required to coat pipe of that length and diameter is then determined from Table 2 above. This amount is then split equally between the ports. By starting at the port farthest away from the vacuum pump in Figure 1, and only supplying one third of the total material required to coat the pipe system at each port, it can be ensured that the common pipe sections between each port and the vacuum pump are not excessively coated.

[0049] After the epoxy layer has hardened, an endoscope may be used to determine whether the pipe system has been completely and evenly coated. An ultrasound device may be used in a known manner to determine the thickness of the epoxy coating layer. A pressure test is also performed to ensure that there are no remaining leaks in the pipe.

[0050] In an exemplary embodiment of the invention, two layers of epoxy are applied to the pipe, to ensure that any sharp edges are sufficiently coated, for example at a pipe union 65 as illustrated in Figures 3 and 4. Figure 3 illustrates the connection of two pipe ends by a screw threaded engagement between the pipe ends, with a single layer 66 of epoxy material applied to the inside of the pipe and across the union. Figure 4 illustrates the application of a second layer 68 of epoxy. After the second coating layer is applied, the interior of the pipe will be relatively smooth and any sharp edges, such as the exposed screw threads at the junction, will be sufficiently coated.

[0051] After the epoxy layer or layers have hardened, the pressure test has been performed, and the coating thickness and uniformity has been tested, the connectors between the renovation system and the pipe system 10 are removed, and the armatures are reinstalled at the pipe ends. The pipes are then operational.

[0052] In an exemplary embodiment of the invention, various quality assuring tests may be carried out during the pipe renovating process. As discussed above, pressure tests are carried out at various points before, during, and after the renovation. The pipes are all coated with epoxy material twice, and the coating is then checked for thickness by ultrasonic means, and for consistency by an endoscope. Endoscopy may also be carried out to check each cleaning step. For cleaning a water pipe, the water quality may be checked both before and after the renovation.

[0053] The pipe renovating method and system of this invention may be used for either installed or non-installed pipes, and can be used to renovate many types of pipes, including water pipes, gas pipes, sewer

pipes, chemical manufacturing plant pipes, fire sprinkler systems, oil pipes, heating ducts, steam pipes and the like. Unlike prior art pipe renovating methods which could not coat and clean large diameter pipes effectively, this method can coat large diameter pipes of up to 20 inches in diameter both economically and efficiently. It has been found that a 10 inch diameter pipe of 120 feet in length can be cleaned and coated within one hour. Unlike this system, which uses a push and pull (pressure and vacuum) technique to move both the abrasive cleaning material and the coating material through the pipe, the prior art uses only pressure or only vacuum, such that air flow is reduced at angles, elbows, valves, partial blockages of the pipe, and the like. In this invention, even if such blockages or impediments are present, the air will be pulled through them by the vacuum pump while still being pushed from the other side by the compressor.

[0054] Another advantage of this invention is that it avoids the need for very high pressures as are needed in prior art pressure only or vacuum only systems. By providing a higher pull or vacuum flow rate than the push or input gas flow rate, steering of the air and abrasive particle or air and coating material mixture can be carried out readily. The combination of push and pull produces more air volume and speed through the pipe, providing more effective cleaning and coating at a lower pressure. The combination of pressure and vacuum also reduces the risk of pipe blockages occurring in the event of equipment failure. In prior art compressor only or vacuum pump only systems, if the compressor or pump should fail during pipe coating, the coating material will stop moving through the pipe and will cure to create a plug, completely blocking the pipe. This is extremely difficult and expensive to fix. With this invention, if

the compressor should fail, the vacuum pump will continue to pull material through the pipe while the compressor is switched out, and vice versa.

[0055] The method and system of this invention helps to avoid or delay the need for a complete or partial re-piping of a pipe system. This considerably reduces expense as well as the down time during renovation. With this method, all that needs to be done is to dismount the devices or instruments at each inlet/outlet of the pipe system, to connect the cleaning and coating system, and to re-connect the devices and instruments after cleaning and coating is complete. The combination of pressure at one end of the pipe section being renovated with vacuum at the other end produces a much more even and constant flow velocity through the pipe, reducing the effect of partial blockages or impediments due to pipe fittings, elbows, bends, or reduction of pipe diameter due to accretions accumulated on the inner surface of a pipe. Even though the pressure at both the intake side and the outlet side may be well below the maximum pressure permitted for safety purposes, for example 15 PSI, particles and liquids can still be transported at very high speed, while reducing the risk of production of leaks due to high pressure in the pipe.

[0056] It should be understood that the supply of abrasive material and coating material may be pumped in at either end of a pipe section to be cleaned, not only in the direction illustrated. Although the cleaning and coating material flow is in the same direction in the illustrated embodiment, this is not essential and cleaning material may flow in one direction while the subsequent flow of coating material may occur in the opposite direction, simply by switching the location of the vacuum pump and compressor. The transport medium in the illustrated embodiment is

air, although other gases may be used in alternative embodiments of the invention.

[0057] Although an exemplary embodiment of the invention has been described above by way of example only, it will be understood by those skilled in the field that modifications may be made to the disclosed embodiment without departing from the scope of the invention, which is defined by the appended claims.

I CLAIM: